Work Orden December - 19-12				*94	656*						Page 1
Item ID: Revision ID:	D3020-1		A	Accept	*N90	<b>0040</b>	100	)* s	Setup Star	<sup>t</sup> *N	S1*
Item Name:	Fitting	•							Stop	, *N	S2*
Start Date: Required Date: Reference:	12/19/12 : 1/11/13	<b>Start Qty:</b> 12.00 <b>Req'd Qty:</b> 12.00	*12* *12*		Cust Iter Custome						
Approvals:	Drooss Dlo	nn: <i>R</i>	Date:/2-20-12	Tooling		Data		F	Run Star	t *N	R1*
Approvais.	QC:		Date:			Date:			Stop	' *N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hour	Tool II	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3020	Rev	γ A									1040
100 *100* Hardinge Hardinge CNC Latl	he Small	Hardinge CNC LATHE S  Memo	MALL s per Folio FA255 and Dwg	0.00 0.00 j	H13/01/08 3-1-7		·· ···· <del>-</del> ··	15	ø		( 13 13 89
110 <b>*110</b> *		QC2- Inspect parts off ma			SS 13/01/08			15	Ø		DAS 13

Quality Control 120

\*120\* Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

Deburr

15 0

												DQA:	Date	e:	
NCR:	Yes	/ No					WORK ORDER NON-	COI	NFORI	MANCE / UP	PDATE			_	
												QA Closed:	Date	e:	
Work Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
						١	Rework	]	ļ	Skid-tube Crosstube			Water Jet	$\neg$	Engineering
Part	۷o.					ı	Scrap		1	Machining	Small Fab	Prod. Eng. Coor.			Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other		
NCR No.						Work Order Update			Large Fab	Composite		Supplier			
Root Desc							ntion of work order update		Initial	Ac	ction	Sign &		一	
Cause		Date	Step	Qty			r Non-conformance	1	nief Eng		cription	Date	Verification		QC Inspector
oc/Data														$\top$	
quip/Tooling		}						}							
perator										·					
Naterial								1		-					
etup								1						1	
ther														1	
rocess															,
upplier															
raining															
napproved								İ						- [	
							F.	AUL	T CATE	GORY					
Landi	ng (	Gear					General		_		_	_			
		Bending			L		Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to (	o/s L		BOM/Route .		Hardwa	re		Over/Under	tolerance		Temperature/Cure
	L	Cracks			L		Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct		Weld
		Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing		Wrong Stock Pulled
		Cuffs					Contamination		]Mainte	nance	Γ	Part Moved	_		
		Heat Trea	it				Countersink		] Mislabe	led		Positioned V	Vrong		
		Inspection	n Strip in	Tube			Cut Too Short		Misread	Í		Power Loss/	Surge	$\Box$	Other
		Ripples in	Bend				Drill Holes		Offset			<u> </u>			
		Torque W	aves in E	xtrusion	1 [		Drawing		Out of (	Calibration					
		Turning S	equence		Γ		Finish	Out of Sequence							

Outside Dimensions

Wave/Twist in Tube

Folio

Work Orde December-19-12				*946	356*						Page 2
Revision ID: Item Name:	D3020-1 Fitting 12/19/12 1/11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		*N900  Cust Item  Customer:	ID:	100	<b>)*</b> \$	Setup Star	1 71	S1* S2*
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Star Sto	1/1	R1* R2*
Sequence ID/ Work Center II  130  *130* QC Quality Control	)	Operation Description QC8- Inspect parts - second	i check	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp / OAS 04 9-89
140 *140 * Packaging Packaging		Identify as per dwg & Stoc Packaging Memo	k Location: <u>IV</u>	<b>0.</b> 00 0.00			Ć	(B)	A	13-	-/-8

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

Memo

0.00

Quality Control

13/1/0 St

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
						•					QA Closed:	Da	ate:	
Work Ord	er:					DISPOSITION			AGA	AINST DI	EPARTMENT	/PROCESS		
Part No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ct	nief Eng	Description		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
1 41				_			AUI	LT CATE	GORY					
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection	Crimped. t n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instructi Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
!	Torque Waves in Extrusion   Drawing   Out of Calibration													

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-19-12 1:53:34 PM

Work Order ID:

94656

Parent Item:

D3020-1

Parent Item Name:

Fitting

**Start Date:** 12/19/12

Required Date: 1/11/13

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP B03.05.06Reformat; Made on CobraKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1018R1.250		Purchased	No			100	f	32.3690	0.0879	1.1103150	5	#5	
1018 ROHND BAR 1 250										1.32			

<b>Location</b>	Loc Qty	Loc Code	
Mezz	32.369		
15925	20.583		
16443	11.786		1.35



												DQA:	Dat	e:	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE		OA Classed			
											_	QA Closed:	Dat	:e:	
Work Ord	er:					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part No.  NCR No.						Scrap Machining Small Use-as-is Thermoforming Finish			Crosstube Small Fab Finishing Composite		Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier				
Root					Descri	otion of work order update	I	Initial	Ac	tion	T	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	1	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		•						-				•			
		· · · · · · · · · · · · · · · · · · ·					AUL	T CATE	GORY		_				
Landi		Bending Centre No Cracks			o/s	General Bend BOM/Route Broken/Damaged		1	on Incomplete			Ovalized Over/Under Part Incorred	ct		Pressure/Forced Temperature/Cure Weld
	П	Crushed/C Cuffs Heat Trea				Burrs Contamination Countersink		Instruct Mainte Mislabe		Unclear		Part Lost/Mi Part Moved Positioned V	_		Wrong Stock Pulled
	Шı	nspection	Strip in	Tube		Cut Too Short		Misread	I			Power Loss/	Surge		Other
	F	Ripples in	Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	94656
Description: Fitting	Part Number:	D3020-1
Inspection Dwg: D3020 Rev: A		Page 1 of 1

	FIRST	T ARTICLE IN	NSPECTI	ON CHE	ECKLIST		
	X	First Arti	cle	Prot	otype		_
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		omments
1.25	+/-0.010	1.249			37-2	Ve	15
0.030 x 45°	+/-0.010	030XY5°					/
0.640	+0.000/-0.010	-634					
0.930	+/-0.010	727					
0.125	+/-0.010	-123					
0.300	+/-0.010	-301					
0.844	+/-0.010	-845	_				
1.030	+/-0.010	1035					
Ø0.750	+0.005/-0.000	-751	/				
0.200	+/-0.010	-200					
			C				
.,	***				,		
***************************************							
	013		· · · ·	DAS			
Measured by:	9-89	Audited by:	图	9-89	Prototype /		N/A
Date: /	3/1/7	Date:	(3,(	٠ρ		Date:	N/A
Rev Date	Change					Revised b	y Approved
1 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	+ <del></del>					KI/IIM	11-1/1

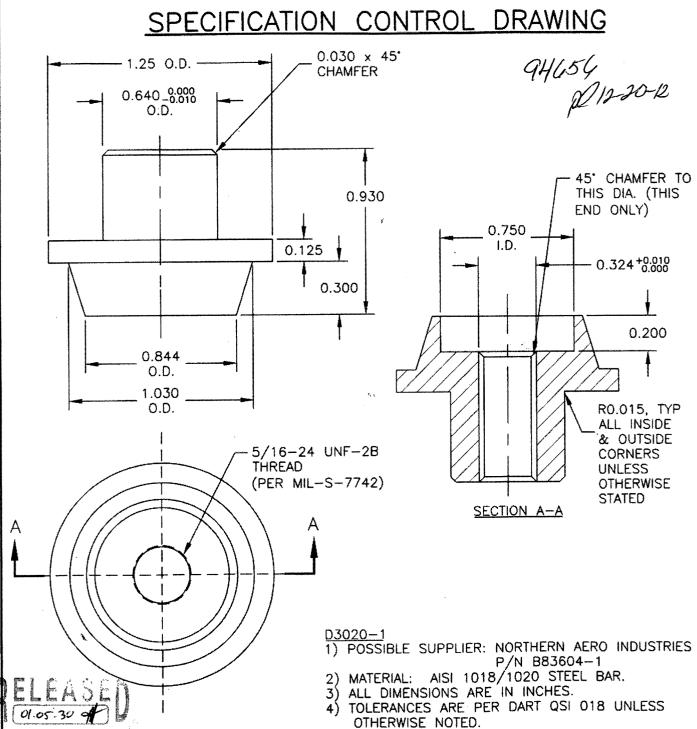
Rev	Date	Change	Revised by	Approx/ed
Α	05.04.26	New Issue	KJ/JLM ox	
<u> </u>				7-7





)	DESIGN (J)	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO,	
	CHECKED /	APPROVED	DRAWING NO.	REV. A
	#	1 at	D3020	SHEET 1 OF 1
	DATE		TITLE	SCALE
	01.05.18		FITTING	2:1
	Α	01.05.18	NEW ISSUE	

## SPECIFICATION CONTROL



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